



Work Order ID 52284

Tuesday, September 22, 2009 1:35:10 PM

Page 1

Item ID: D3202-3 **GY** Accept  Setup Start 
Revision ID: D Stop 
Item Name: Cover
Start Date: 9/23/2009 Start Qty: 8.00  Cust Item ID:
Required Date: 10/6/2009 Req'd Qty: 8.00  Customer:
Reference:

Approvals: Process Plan: RF MF Date: 9-9-22 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3202	Rev D								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3202 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Deburr if necessaryHB 9-9-29(13)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-9-29

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

13HB 9-9-29

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Item ID: D3202-3

Accept

Revision ID: D

Item Name: Cover

Start Date: 9/23/2009 Start Qty: 8.00

Required Date: 10/6/2009 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

7.28 0910830

X13

Ø



HandFinish

Memo

0.00

Hand Finishing

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

7.28 0910130

X13

Ø



Powdercoat

Memo

Powder Coating

START TIME: 7:30 PM OVEN TEMPERATURE:
FINISH TIME: 3:00 PM 320°F

150

QC3- Inspect Part Finish

0.00

0.00

15K 09-10-1

13



QC

Memo

Quality Control

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Item ID: D3202-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Cover

Start Date: 9/23/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>I41A</u>	0.00							
Packaging 	Memo	0.00				9/10/1		130 SP	
Packaging									
170 	QC21 - Final Inspection - Work Order Release	0.00							
QC 	Memo	0.00							
Quality Control									

09/10/01

MF
09-10-01

Picklist Print

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Work Order ID: 52284



Parent Item: D3202-3RevD



Parent Item Name: Cover

Start Date: 9/23/2009

Required Date: 10/6/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	119.1237	13.0611	28.000		
5052-H32 .032 Sheet												

HB 9-9-24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

119.1237

100470

6

103321

3

105998

7.14

108462

13

109478

4.32

111448

11.5137

112664

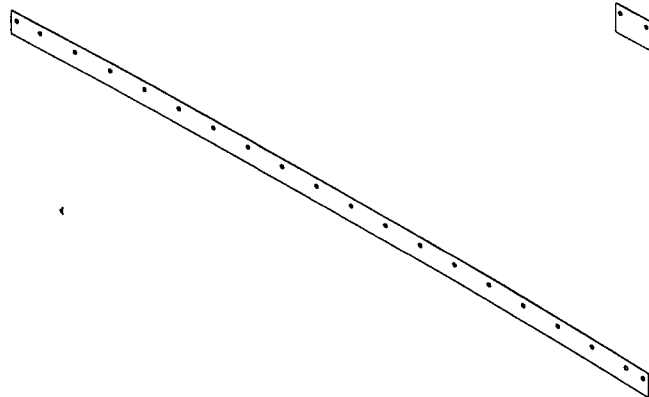
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15031

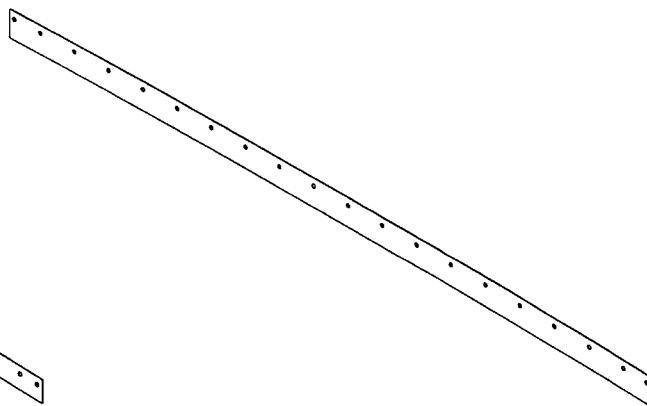
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112664

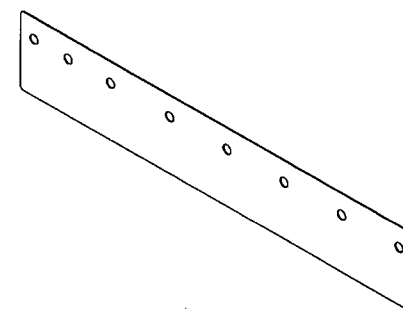
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 52284



D3202-1 COVER



**D3202-3 COVER
 (COMPOSITE DOOR)**



**D3202-5 COVER
 (HINGE PANEL DOOR MOD)**

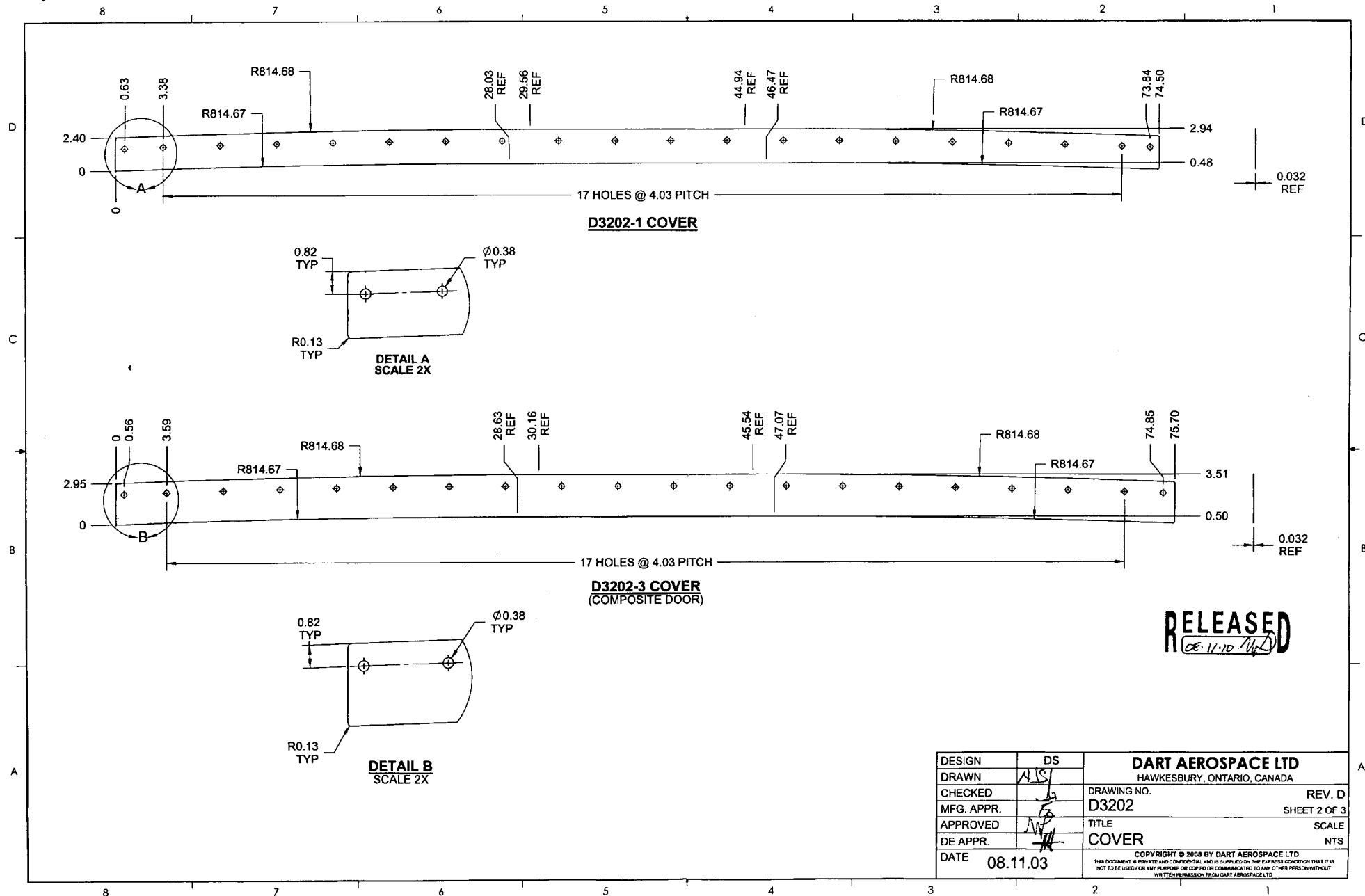
RELEASED
 08.11.10

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
 PER AMS-QQ-A-250/8 OR AMS 4016
 REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
 : 0.61 lbs APPROX FOR -3
 : 0.18 lbs APPROX FOR -5

D	ADD -5 FOR HINGE PANEL DOOR MOD.	AJS	08.11.03
C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 1 OF 3
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DE APPR.		COVER	NTS
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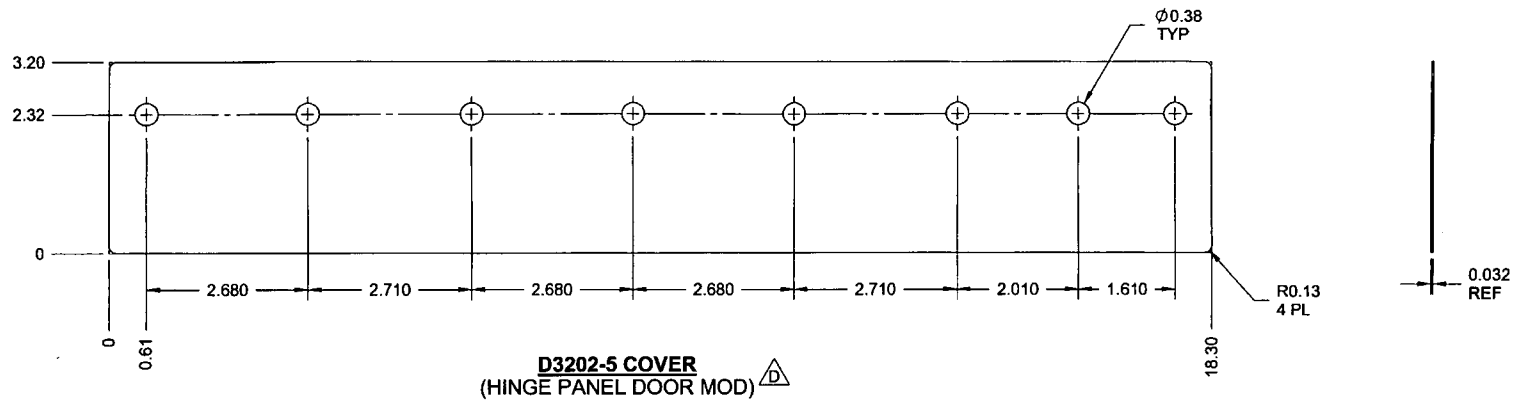
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08.11.10 1/42

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08.11.03

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